

WHAT IS CLAIMED IS:

1. A board transferring apparatus for transferring boards between the apparatus and a component-mounted board production apparatus, which comprises;

5 an unprocessed board transfer unit including an unprocessed board transfer path along which an unprocessed board as the board not processed by the component-mounted board production apparatus is transferred, and an unprocessed board carry-in device which moves between the 10 unprocessed board transfer path and the component-mounted board production apparatus thereby carrying the unprocessed 14 or 20, 22 board into the component-mounted board production 20, 22 apparatus;

15 a process-finished board send-out unit including a process-finished board transfer path along which a process-finished ^{11a, 12c} board as the board processed by the component-mounted board production apparatus is transferred, for carrying the process-finished board out from the 20, 22 component-mounted board production apparatus by moving between the process-finished board transfer path and the component-mounted board production apparatus; and

20 ¹⁸ a shift device which moves between the unprocessed board transfer path and the process-finished ⁴⁰ board transfer path and for shifting the board between the ^{92, 44} unprocessed board transfer path and the process-finished 25 unprocessed board transfer path and the process-finished

board transfer path.

2. The board transferring apparatus according to
claim 1, wherein at least one shift device is equipped when
a plurality of the component-mounted board production
5 apparatuses are arranged in series in a transfer direction
of the unprocessed board and the process-finished board.

3. The board transferring apparatus according to
claim 2, further comprising a controller for controlling
operations of the unprocessed board transfer unit, the
10 process-finished board transfer unit and the shift device.

4. The board transferring apparatus according to
claim 3, wherein, in a case where a plurality of the
component-mounted board production apparatuses for
executing different processes are arranged along the
15 transfer direction of the unprocessed board and the
process-finished board, the shift device is disposed
between a first component-mounted board production
apparatus and a second component-mounted board production
apparatus for executing mutually different processes, while
20 the controller controls the shift device to shift the
process-finished board carried out from the first
component-mounted board production apparatus to the
process-finished board transfer path to the unprocessed
board transfer path.

25 5. The board transferring apparatus according to

claim 4, wherein the controller controls the operations of the unprocessed board transfer unit, the process-finished board transfer unit and the shift device on a basis of an arrangement of the component-mounted board production apparatus along the transfer direction and a processing program to be executed to the boards.

6. A component mounting apparatus comprising the board transferring apparatus according to claim 4.

7. The component mounting apparatus according to claim 6, wherein, when the first component-mounted board production apparatus and the second component-mounted board production apparatus are component supply/mounting machines, and all components to be mounted to the unprocessed board having the first components and the second components, the controller makes the first component-mounted board production apparatus mount first components, the shift device carry a process-finished board with the first components mounted into the second component-mounted board production apparatus, and the second component-mounted board production apparatus mount second components.

8. A board transfer method which comprises:

carrying an unprocessed board as a board not processed by a component-mounted board production apparatus from an unprocessed board transfer path into the component-mounted board production apparatus;

DRAFTING STANDARDS

12a, 12c

sending out a process-finished board as processed
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board to a process-finished board transfer path after
processing in the component-mounted board production
apparatus; and

5 moving the process-finished board of the process-
12a
finished board transfer path to the unprocessed board
transfer *52* path.

9. The board transfer method according to claim 8,
with a plurality of the component-mounted board production
10 apparatuses being arranged *14, 16* in series along a transfer
direction of the unprocessed board and the process-finished
board, between a first component-mounted board production
apparatus and a second component-mounted board production
apparatus for executing mutually different processes,
15 moving the process-finished board carried out from the
first component-mounted board production apparatus to the
process-finished board *36* transfer path to the unprocessed
52
board transfer path, and
carrying *42, 44, 52* the process-finished board into the
20 second component-mounted board production apparatus.

10. The board transfer method according to claim 9,
in which the carrying of the unprocessed board from the
unprocessed board transfer path to the component-mounted
board production apparatus, the shifting of the process-
25 finished board from the process-finished board transfer

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path to the unprocessed board transfer path, and the carrying of the process-finished board into the second component-mounted board production apparatus are controlled on a basis of an arrangement of the component-mounted board production apparatuses along the transfer direction and a processing program to be executed to the boards.

11. A board transferring apparatus for transferring boards on a board transfer path and between the board transfer path and a component-mounted board production apparatus while the component-mounted board production apparatus is disposed along the board transfer path where the boards are transferred in a transfer direction, which comprises:

15 a board carry-in unit which moves between the board transfer path and the component-mounted board production apparatus thereby carrying the board into the component-mounted board production apparatus;

20 a board send-out unit which moves between the board transfer path and the component-mounted board production apparatus thereby sending out the board from the component-mounted board production apparatus to the board transfer path;

25 an identifying device disposed to the board transfer path for identifying a carry-in propriety display part on the board indicative of whether or not the board

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can be carried into the component-mounted board production apparatus; and

5 a controller for determining whether or not the board is to be carried into the component-mounted board
 production apparatus on a basis of the identification result of the carry-in propriety display part identified by the identifying device, and controlling the operation of the board carry-in unit.

12. The board transferring apparatus according to
10 claim 11, wherein, when the controller determines that the board is to be carried into the component-mounted board production apparatus on the basis of the identification result, the controller is adapted to carry the board by the board carry-in unit into the component-mounted board production apparatus, process the board by the component-mounted board production apparatus and send out the processed board to the board transfer path by the board send-out unit.

13. The board transferring apparatus according to
20 claim 12, in which the component-mounted board production
 apparatus is arranged by a plurality of the number in
 series along the board transfer path, with the identifying device being disposed corresponding to each of the component-mounted board production apparatuses, whereby the
25 controller determines on the basis of the identification

result whether or not the identified board is to be carried into the component-mounted board production apparatus and lets the identified board be transferred along the board transfer path in the transfer direction when determining 5 that the identified board is not to be carried into the component-mounted board production apparatus.

14. The board transferring apparatus according to claim 13, which further comprises a recognizing device disposed corresponding to a component-mounted board production apparatus arranged to a trail end in the transfer direction among the plurality of the component-mounted board production apparatuses for recognizing a propriety of processing by the component-mounted board production apparatus for the board transferred along the board transfer path.

15. The board transferring apparatus according to claim 11, wherein the carry-in propriety display part is a mark preliminarily applied to the board.

16. A component mounting apparatus with the board transferring apparatus according to claim 11.

17. A board transfer method for transferring boards to a board transfer path and between the board transfer path and a component-mounted board production apparatus disposed along the board transfer path where the boards are transferred in a transfer direction, which comprises:

identifying a carry-in propriety display part of
the board transferred along the board transfer path; and
determining on the basis of the identification
result whether or not the board is to be carried into the
component-mounted board production apparatus.

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18. The board transfer method according to claim 17,
wherein, when it is determined that the board is to be
carried into the component-mounted board production
apparatus, the board is carried into the component-mounted
board production apparatus, processed by the component-
mounted board production apparatus and then carried out
from the component-mounted board production apparatus to
the board transfer path.

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